

Work Order ID 75946

November 2, 2011 8:22:17 AM

75946

Page 1

Item ID: D3255 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 11/02/11 Start Qty: 54.00 ***54*** Cust Item ID:
 Required Date: 11/04/11 Req'd Qty: 54.00 ***54*** Customer:
 Reference:

Approvals: Process Plan: CZ Date: 11/11/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 15334 Email or Ship DXF file to vendorPossible
 Supplier: Beuco Inc. Material: Silicone coated fiberglass cloth per AMS
 3320F P/N: SIL/F 36' x 36' x 1/16"certificat of conformaty required
CZ 11/11/02 54SF

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached
Per 11/11/11 (54)

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control Sublot
x 9 Reels.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75946

75946

Page 2

November 2, 2011 8:22:17 AM

Item ID: D3255 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 11/02/11 Start Qty: 54.00 ***54*** Cust Item ID:
 Required Date: 11/04/11 Req'd Qty: 54.00 ***54*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>412</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/11/11
 11-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 2, 2011 8:22:17 AM

Page 1

Work Order ID: 75946

Parent Item: D3255

Parent Item Name: Gasket

Start Date: 11/02/11

Required Date: 11/04/11

Start Qty: 54.00

Required Qty: 54.00

Comments: IPP A04.04.06New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SIL/F36X36X1/16 Gasket		Purchased	No			100	sf	0.0000	1	54		11/11/11	By

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

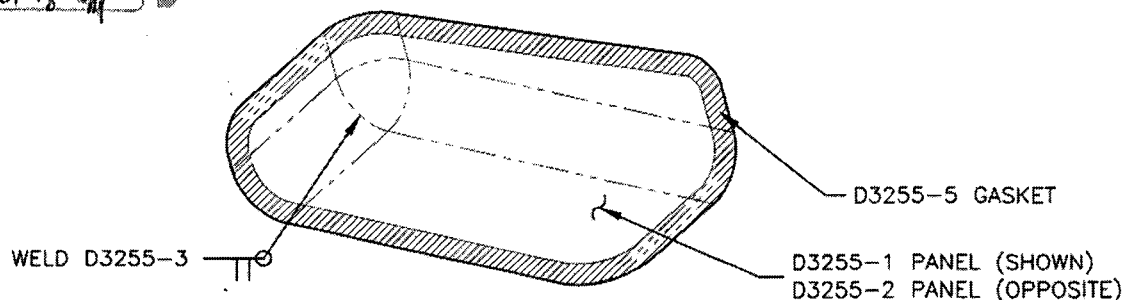
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

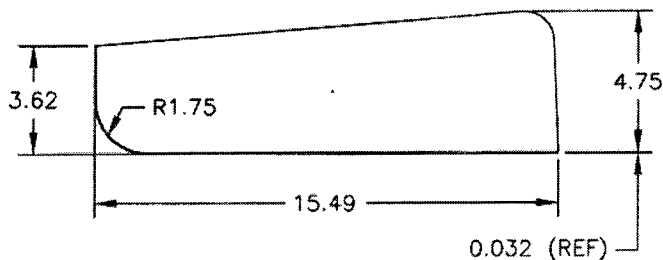
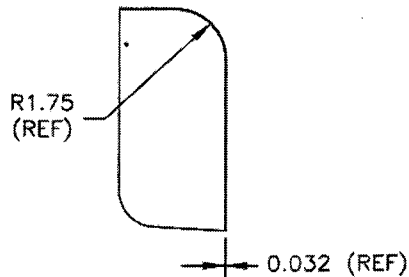
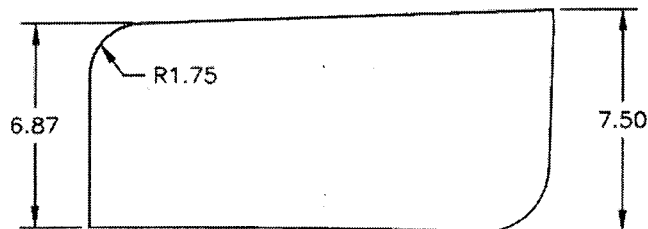


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

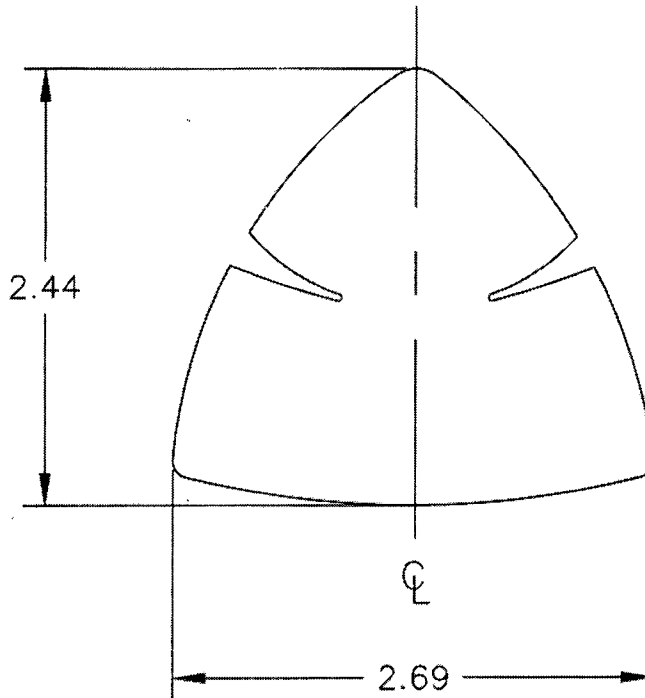
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 47	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 #



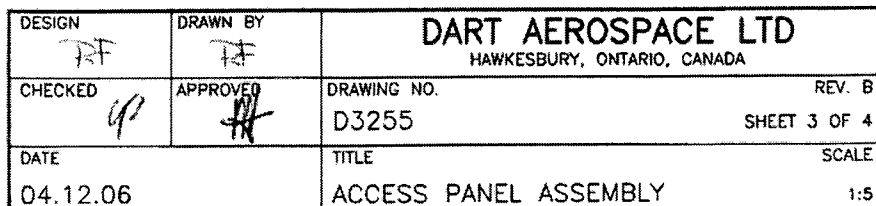
D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

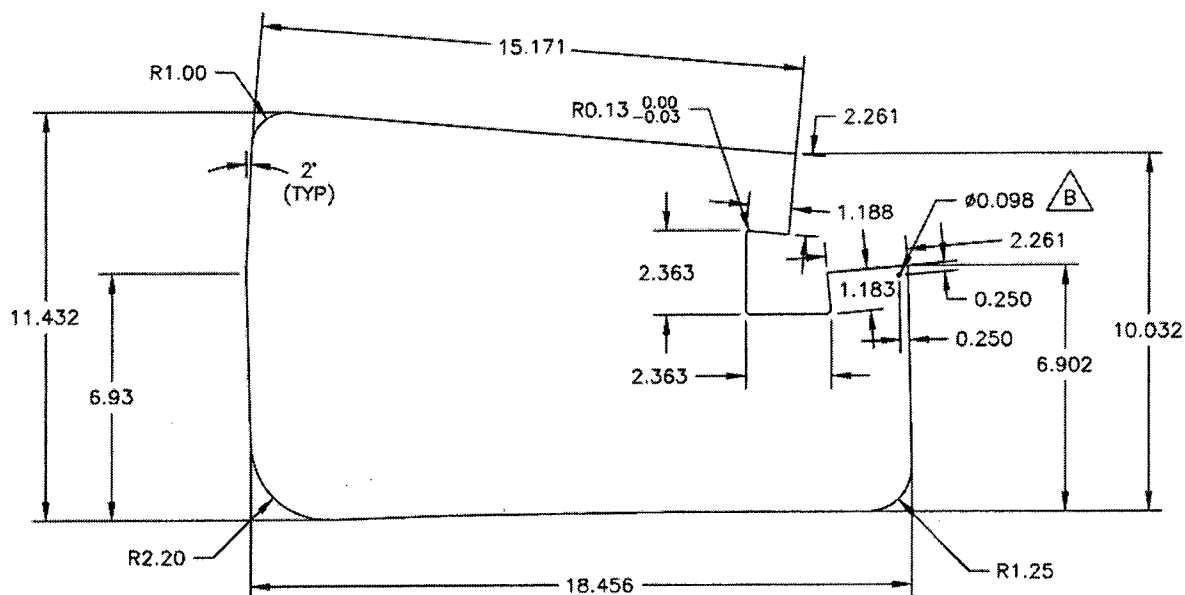
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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RELEASED
05-01-18



D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

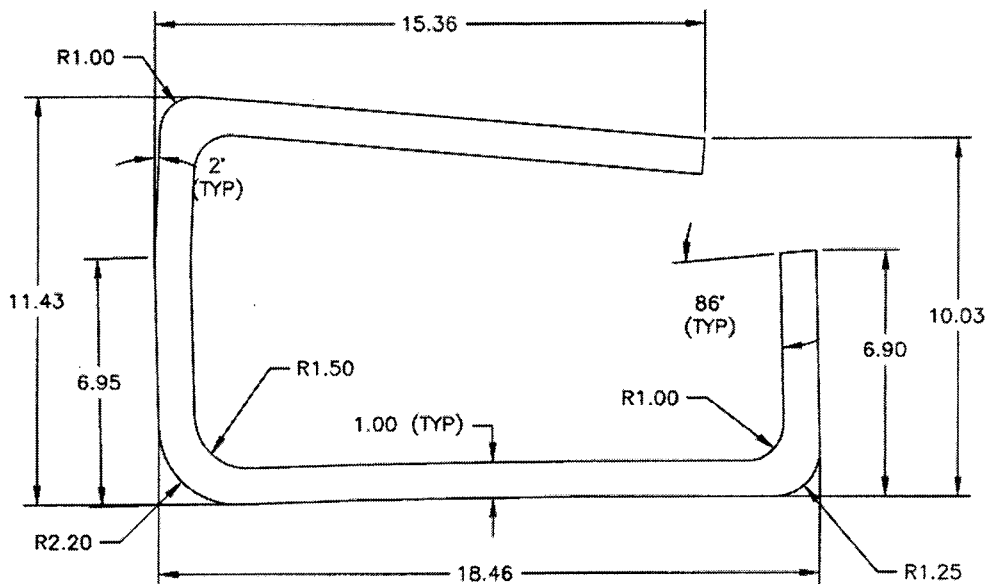
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 JF



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15334

Purchase Order Date 11/02/11

PO Print Date 11/02/11

Page Number 1 of 2

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone

330 995 5500

Vendor Fax

330 995 9600

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	SIL/F36X36X1/16	Gasket	11/04/11 Yes	54.00 sf	FedEx PI collect	\$11.3567	\$613.26
			Special Inst: AS PER DWG D3255 REV. B B75946 MCMaster P/N: 8612K61				
2		3069A21 3/16" cobalt DRILL	11/04/11 No	36.00 Each	FedEx PI collect	\$2.7400	\$98.64
			Deliver To: DAN.P				
3		27995A519 3/16" COBALT DRILL	11/04/11 No	12.00 Each	FedEx PI collect	\$4.8200	\$57.84
			Deliver To: DAN.P				

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 11/02/11



Purchase Order
PO15334

Page 1 of 2

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
le.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Dan P

McMaster-Carr Number
5465631-02

11/02/2011

A83

Line	Description	Ordered	Shipped						
1	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36" = 6	9 Each	8	8 - 64 - 37	86 - 73	K61	8 EA	1	
	Unit Price: \$68.14			21 lbs					
	Extended Price: \$545.12								
2	3069A21 Heat-Resistant Cobalt Steel Jobbers Drill Bit, 3/16", 3-1/2" Overall Lg, 2" Drill DP, 135 Degree Point	36 Each	36	2 - 504				2	
	Unit Price: \$2.74								
	Extended Price: \$98.64								
3	27995A519 Tin-Coated Cobalt Steel Jobbers' Drill Bit, 3/16", 3-1/2" Overall Lg, 1.9" Drill DP, 135 Degree Point	12 Each	12	2 - 506					
	Unit Price: \$4.82								
	Extended Price: \$57.84								
4	28775A61 Hand-Driven Countersink, Includes Handle and 4 Blades	2 Each	2	2 - 503				4	
	Unit Price: \$53.21								
	Extended Price: \$106.42								

Shipped separately from our Chicago warehouse on 11/02

Dart Aerospace Ltd

EXP
INV
NAFTA



23 lbs
4 lines

Lg

38x12x12

FW1RFV59
11/02/2011
12:21/12:57
788
Cycle 39

1140187073993



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Dan P

McMaster-Carr Number
5465631-01

11/02/2011

Line	Description	Ordered	Shipped					
1	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	1	8 - 36 - 49	45 - 78	K61	1 EA	1
	Unit Price:	\$68.14						
	Extended Price:	\$68.14						

Sumila

Shipped separately from our Cleveland warehouse on 11/02

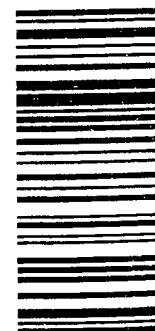
1	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	8					
2	3069A21 Heat-Resistant Cobalt Steel Jobbers Drill Bit, 3/16", 3-1/2" Overall Lg, 2" Drill DP, 135 Degree Point	36 Each	36					
3	27995A519 Tin-Coated Cobalt Steel Jobbers' Drill Bit, 3/16", 3-1/2" Overall Lg, 1.9" Drill DP, 135 Degree Point	12 Each	12					
4	28775A61 Hand-Driven Countersink, Includes Handle and 4 Blades	2 Each	2					

Charges for this shipment

Merchandise Amount:	\$68.14
Total:	\$68.14

Dart Aerospace Ltd

EXP
INV
NAFTA



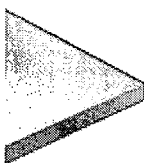
3 lbs
1 line

EW1VH021
11/02/2011
12:21/12:56
032
Cycle 36



Rubber and Foam

Catalog Page | Bookmark

**8612K61**

Each

In stock for \$68.14

Material Type	Fabric-Reinforced Silicone Rubber
Shape	Sheets, Bars, and Strips
Backing	No Backing
Thickness	1/16"
Thickness Tolerance	±0.012"
Length	36"
Length Tolerance	+1"
Width	24"
Width Tolerance	+1", -1/4"
Durometer	Hard
Durometer Rating	70A
Durometer Hardness Tolerance	±10
Temperature Range	-100° to +500° F
Tensile Strength	1100 psi
Color	Red
Finish	Smooth
Tolerance	Standard
Specifications Met	Aerospace Material Specifications (AMS)
AMS Specification	AMS 3320G
Properties	Weather Resistant
Notes	Rubber, but not fabric insert, meets AMS 3320G. Rubber has a lightweight fiberglass fabric insert in the center of material.

see note on w/o 63846 on






last letter "G"
Jul 11/02

Work Order ID 63846



November 16, 2010 1:31:31 PM



Page 1

Item ID: D3255 Accept  Setup Start 
Revision ID: Stop 
Item Name: Gasket
Start Date: 11/16/10 Start Qty: 54.00  Cust Item ID:
Required Date: 11/19/10 Req'd Qty: 54.00  Customer:

Reference:

Approvals: Process Plan: C2 Date: 10/11/16 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12936 ☐ Email or Ship DXF file to vendor ☐ Possible
Supplier: Beuco Inc. ☐ Material: Silicone coated fiberglass cloth per AMS
3320F ☐ P/N: SIL/F 36' x 36' x 1/16" ☐ certificat of conformaty required

C2 10/11/16 5485

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

10/11/25
SEE
ATTACHED.


10/11/25

730

REFERENCE OUT

REFERENCE ONLY

Rubber and Foam



Part Number: 8612K61	\$65.50 Each
Material Type	Fabric-Reinforced Silicone Rubber
Shape	Sheets, Bars, and Strips
Backing	No Backing
Thickness	1/16"
Thickness Tolerance	±0.012"
Length	36"
Length Tolerance	+1"
Width	24"
Width Tolerance	+1", -1/4"
Durometer	Hard
Durometer Rating	70A
Durometer Hardness Tolerance	±10
Temperature Range	-100° to +500° F
Tensile Strength	1100 psi
Color	Red
Finish	Smooth
Tolerance	Standard
Specifications Met	Aerospace Material Specifications (AMS)
AMS Specification	AMS 3320G
Properties	Weather Resistant, Electrical Resistant
Notes	Rubber, but not fabric insert, meets AMS 3320G. Rubber has a lightweight fiberglass fabric insert in the center of material.

THE LETTER "G" INDICATE REVISION STATUS.
DRAWINGS INDICATE "F".

MATERIAL IS THEREFORE ACCEPTABLE ON
THE BASIS THAT IT CONFORMS TO
A LATER AND MORE STRINGENT
REVISION OF SAME SPEC.

L.O. 11.25